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refut

D3121-25
Job Sheet 190869



Part No: D3121-25

Job Qty: 50 pcs

Part Name: Delrin Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/19/19

Job Tracking No:

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: Stock *SAD*

Description:

Note: DWG REV E IPP Rev:A New Issue 06-05-10 JLM IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	50 pcs	3/8/19	3/8/19	0.00	0.00	Hardinge - 1		<i>JSD 19/3/1</i>
120	QC 8	50 pcs	3/8/19	3/8/19	0.00	0.00	QC 8 - 12		<i>9m 19/03/04</i>
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 47		
130	Packaging 3-1 - Stock - B4B	50 pcs	3/8/19	3/8/19	0.00	0.00	Packaging 3 - 1 - B4B		<i>57018900 MAR 04 2019</i>
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		

				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
140	QC 21 - SA	50 pcs	3/8/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - Hardinge -1-Turn D3121-25 Cap as per Folio FA387 Descriptions: 120 - QC8- Inspect parts - second check 130 - Identify as per dwg & Stock Location: _____ 140 - QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MDELRR1.000	Delrin Round Bar 1" Color: Black	1.6000 ft (.032 ea)	100-Hardinge - 1	5149262	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Hardinge - 1	MDELRR1.000	2	15	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cap	0.315inches ± 0.010	0.325 0.305		
2	Cap	1.000inches ± 0.010	1.010 0.990		
3	Cap	0.838inches ± 0.002	0.840 0.836		
4	Cap	0.063inches ± 0.010	0.073 0.053		
5	Cap	0.010inches ± 0.010	0.020 0.000		
6	Cap	0.230inches ± 0.001	0.231 0.229		
7	Cap	0.865inches ± 0.001	0.866 0.864		

DART AEROSPACE LTD		Work Order:	190869
Description: Cap		Part Number:	D3121-25
Inspection Dwg: D3121 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.315	+/-0.010	.316	✓		Vernier	
Ø1.000	+/-0.010	.996	✓		"	
Ø0.838	+/-0.002	.840	✓		"	
R0.063	+/-0.010	.062	✓		"	
R0.010	+/-0.010	.016	✓		"	
0.230	+/-0.001	.231	✓		"	
Ø0.865	+/-0.001	.865	✓		"	

Measured by: JBD	Audited by: Juf	Prototype Approval:	N/A
Date: 19/3/11	Date: 19/03/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3121-241)	KJ/RF	
B	06.06.09	Ø1.000 diameter was Ø1.024	KJ/JLM	
C	08.01.16	Dwg Rev. updated	KJ/EC/DD	DD



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Container No: S158219



Part: D3121-25

Job No: 190869

Serial No/Batch: S158219

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/01/19